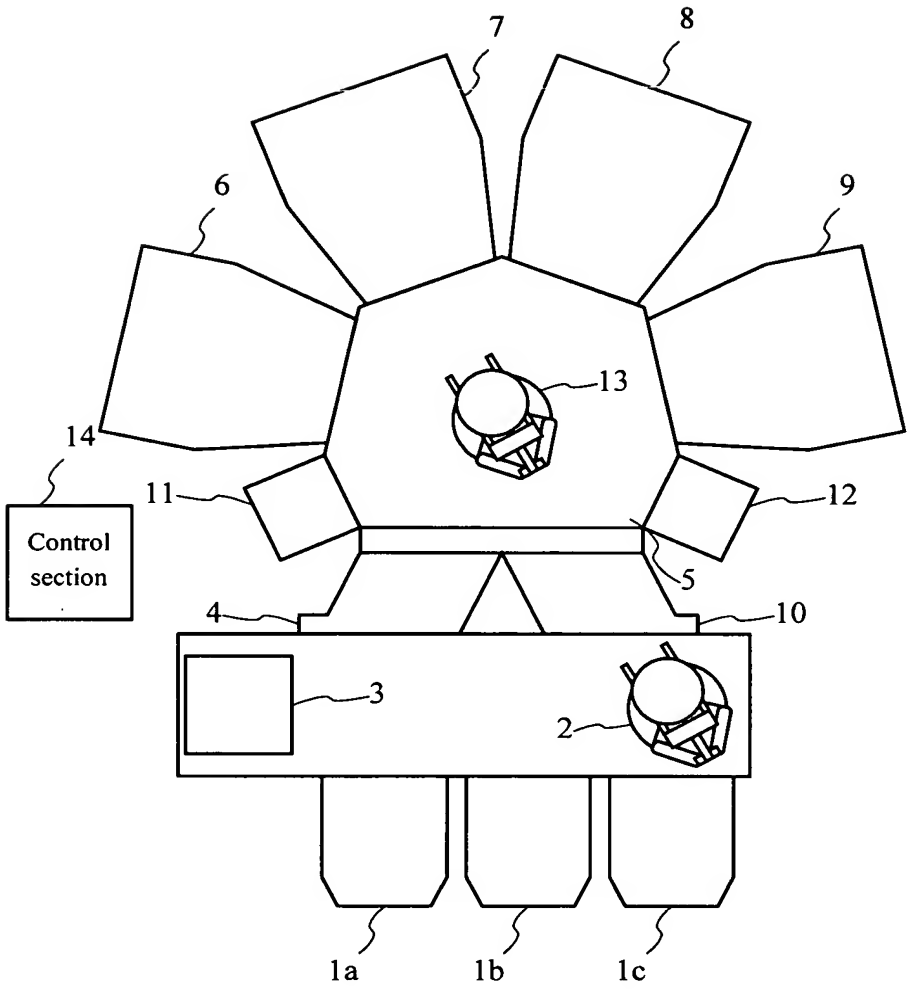
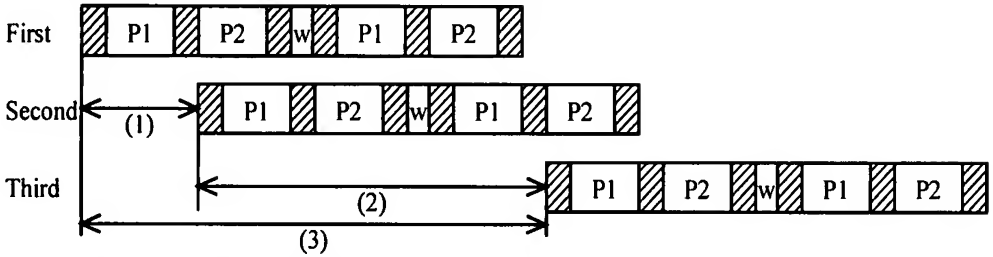


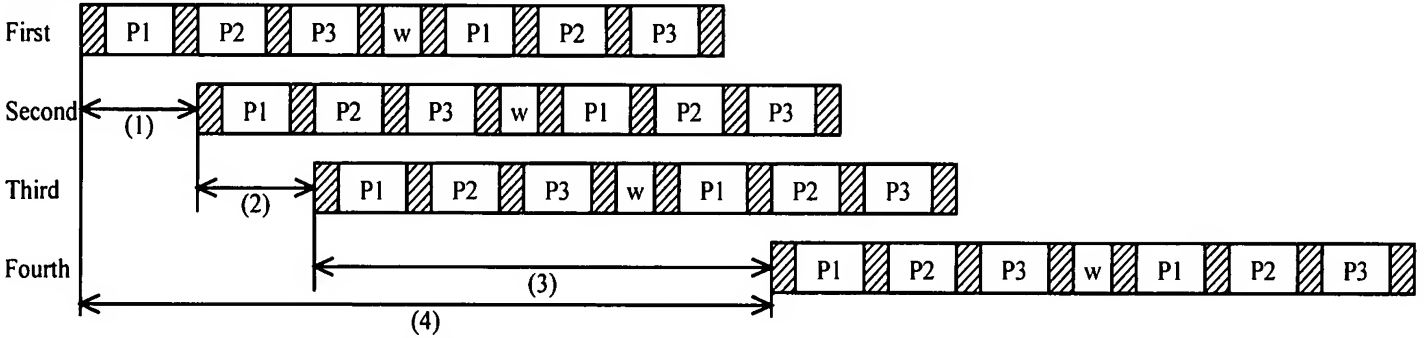
Fig.1

(A) When the number of continuous processes is two



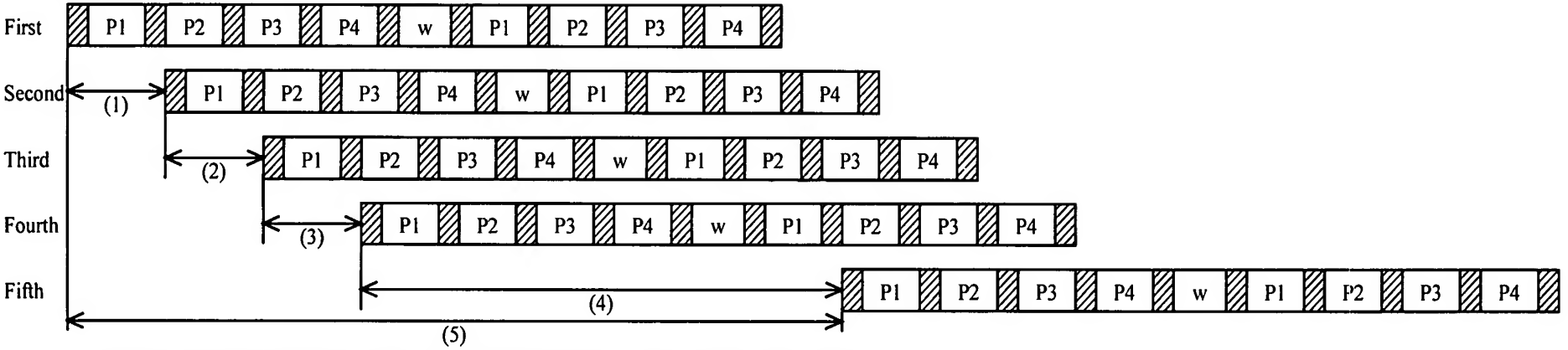
Cycle time when the number of continuous processes is two : CT1'=(3)/2=(4P+8T)/2

(B) When the number of continuous processes is three



Cycle time when the number of continuous processes is three : CT2'=(4)/3=(6P+12T)/3

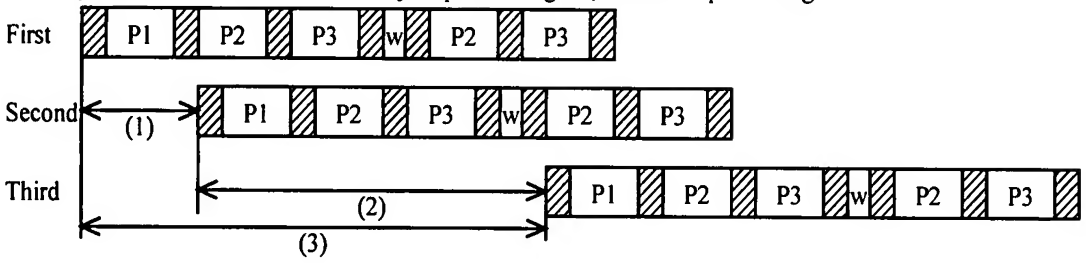
(C) When the number of continuous processes is four



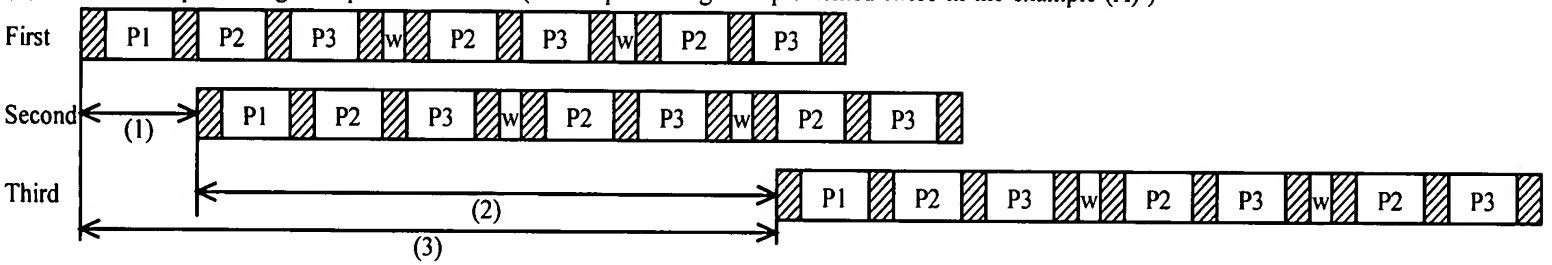
Cycle time when the number of continuous processes is four : CT3'=(5)/4=(8P+16T)/4

Fig.2

(A) In processes P1, P2, P3, when only implementing P2, P3 return processing



(B) When return processing is implemented twice (return processing is implemented twice in the example (A))



(C) When process times are different

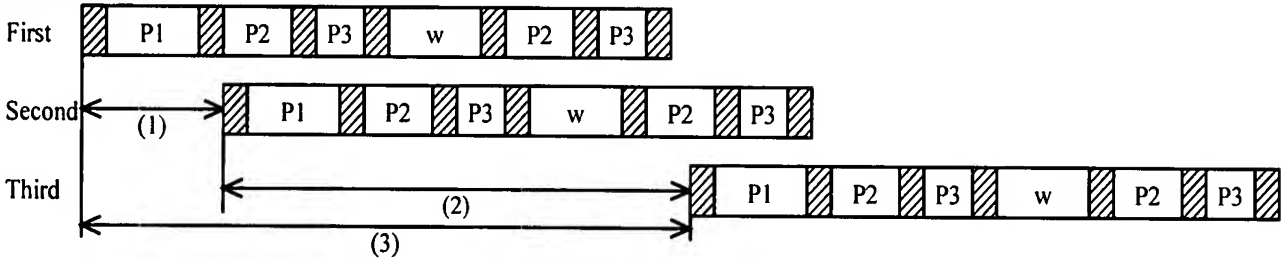


Fig.3

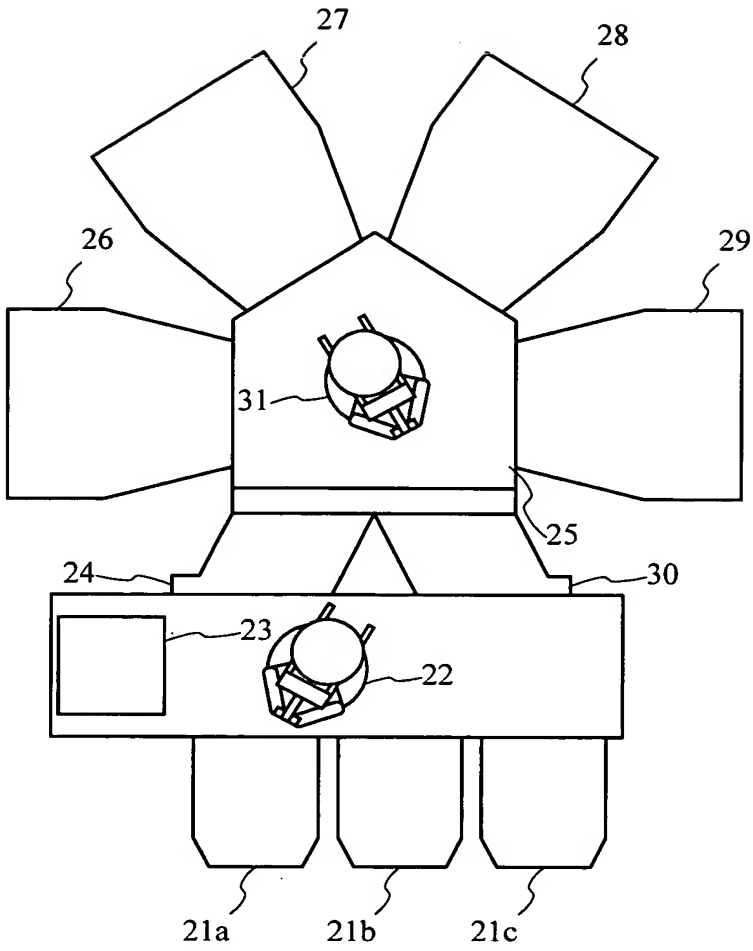


Fig.4

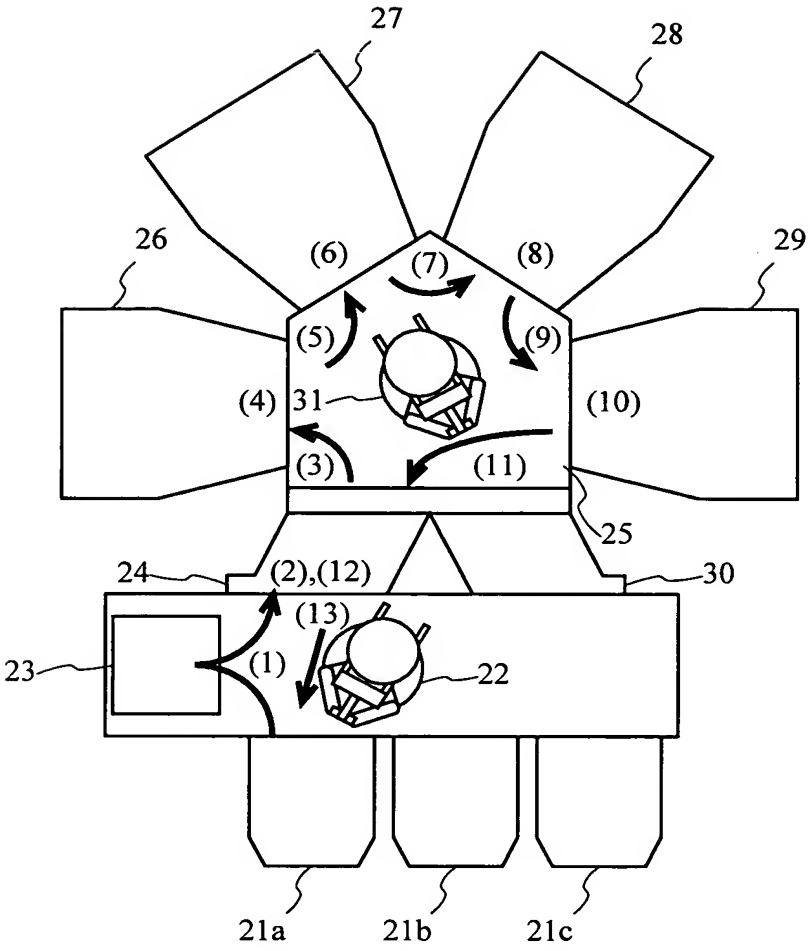
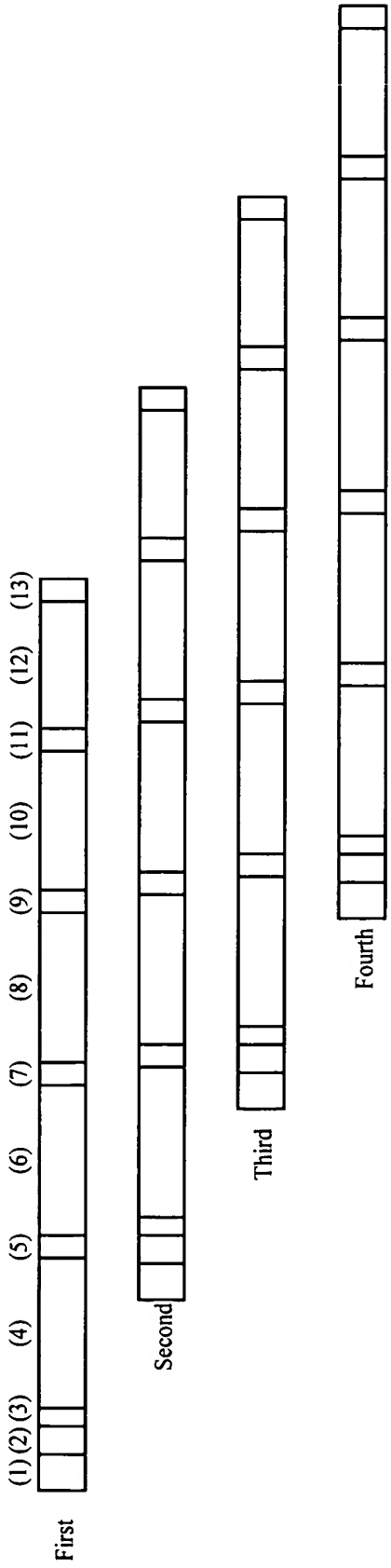


Fig.5

Fig.6



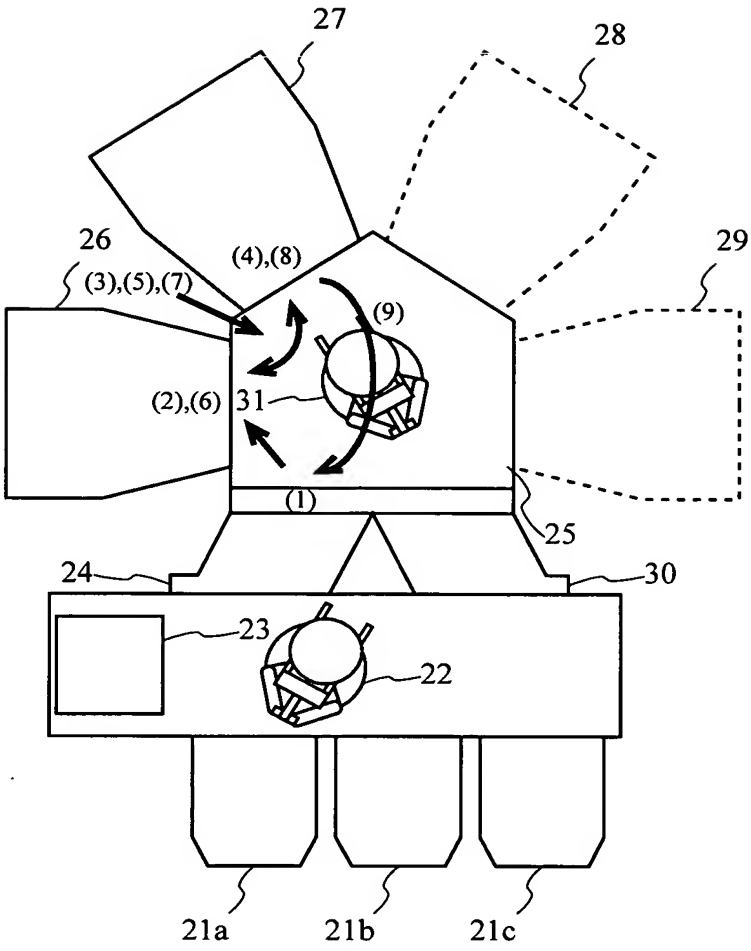
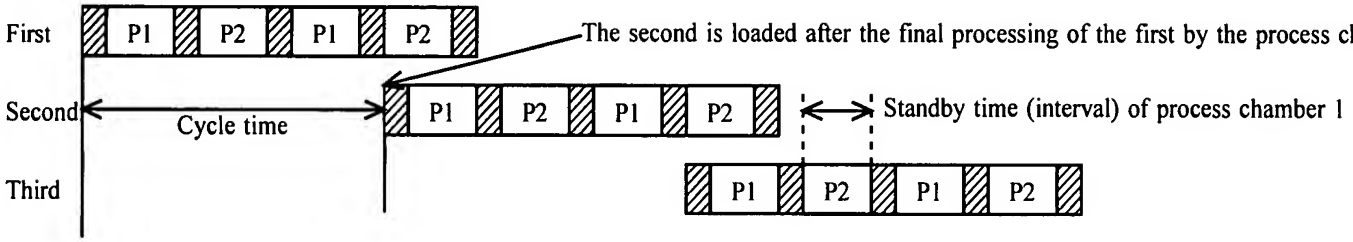


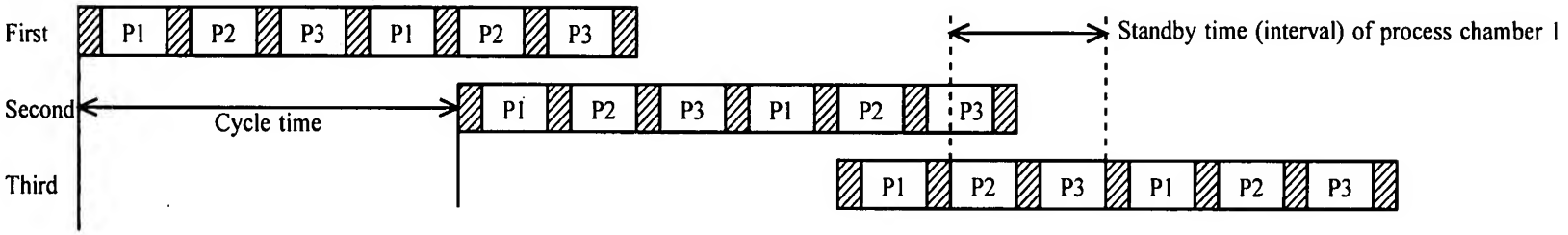
Fig.7

(A) When the number of continuous processes is two



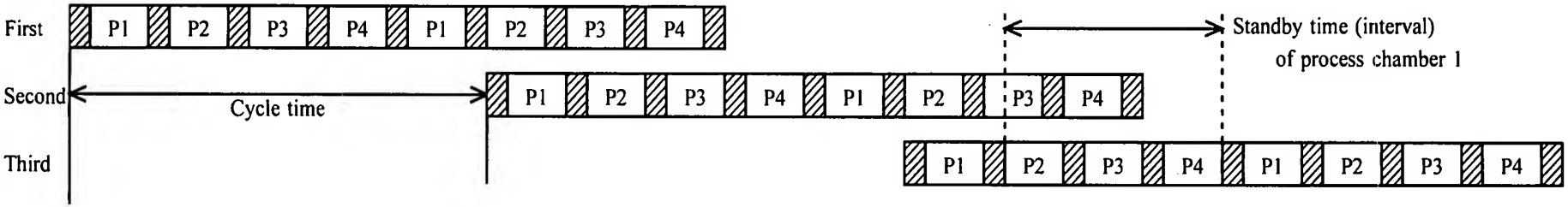
Cycle time when the number of continuous processes is two : CT1=3P+4T

(B) When the number of continuous processes is three



Cycle time when the number of continuous processes is three : CT2=4P+5T

(C) When the number of continuous processes is four



Cycle time when the number of continuous processes is four : CT3=5P+6T

Fig.8